

Ship ASAP

Dart Aerospace Ltd.

Date: Wednesday, 1/23/2008 11:31:02 AM
User: Kim Johnston

Process Sheet

8/10/24

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM	
Job Number	: 36909		Part Number	: D2037101	
Estimate Number	: 10145		Drawing Number	: D2037 REV C3	
P.O. Number	:		Project Number	: N/A	
This Issue	: 1/23/2008	S.O. No. :	Drawing Revision	: C3	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : SMALL / MED FAB	Due Date	: 2/1/2008	
Previous Run	: 36886C		Qty:	6	
Written By	:		Um:	Each	
Checked & Approved By	: <u>HD</u> 08/01/23				
Comment	: Est Rev:A New Issue 05-11-01 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 4.1118 f(s)/Unit Total : 41.1180 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049) Batch: B106015 x 3 / 105988 x 3	FF 08-01-24
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1	FF 08-01-24
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037	
		2-Flatten ends of D2037-101 tube as required using DT8545	
		3-Deburr as required	FF 08-01-24
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	5 08/01/09 (46)
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: N/A	to Steve (Frances) FC 08/01/30 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description:
6.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		2008/1/31 (6)

Job Completion



2008/1/31 (6)

W

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

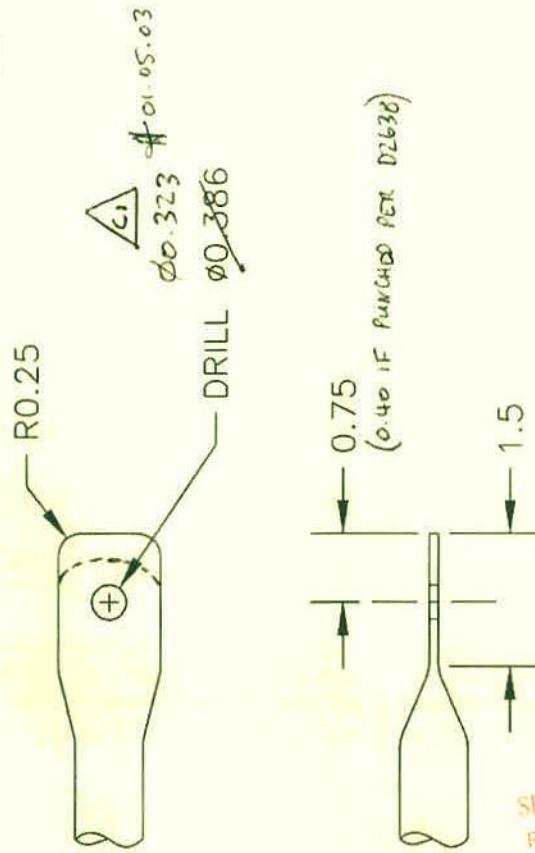
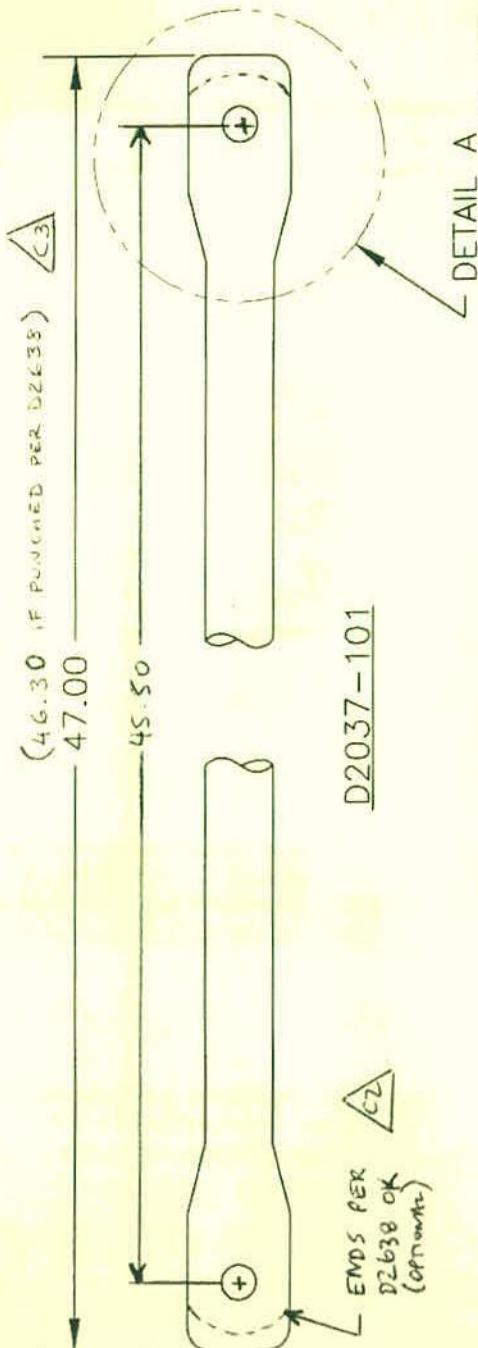
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

copy issued
Date

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED J	DRAWING NO. D2037	REV. C SHEET 1 OF 1
DATE 99.06.07		TITLE ARM	SCALE NTS
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	IP 01.05.03	CHANGE TO $\phi 0.323$	
C2	IP 02.06.14	ADD PUNCH PER D2638 AS OPTION	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36909

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3 ~~IP~~ 05.04.27 ADD 46.30 PUNCHED PER D2638

RELEASED
KE 99.06.10

